Work Ordenserver September - 23-1.					*107	7238*						Page	1
Item ID:	D3913-04	l	••		Accept	*N900	Ω	100) * s	etup Sta	rt * 	Q1 *	
Revision ID:						IU.A.N.	\	/ .	•		IV		
Item Name:	Long Baske	t Base Ass	semby, 350							Sto	^p *N	S2*	
Start Date:	10/02/13	Start	t Qty: 1.00	*1*		Cust Item I	D:						
Required Date:	10/07/13	Req'	d Qty: 1.00	*1*		Customer:							
Reference:				•									
Approvale	Drogge I	Dlane		Date: 13-04	72 Tooling:	D.	ate:		F	Run Sta	rt *N	R1 *	
Approvals:			, (Sto)p		
	QC:	<u> </u>		Date:	SPC (Y/N):	Da	ate:				^N	Rフ [*]	
Sequence ID/ Work Center I	D	Opera Descr	ation ription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	_
Draw Nbr	R	evision N	Nbr										
D3913	C												
D4020	Α		i										
100		Weld p	per dwg A/R S.S	6. rod Batch: <u>B/2</u>	3 <i>823</i> 0.00								
100		Large	Fab							"/3-	-10-2	?2	
Large Fab			Memo		0.00								
Large Fab				e ribs, weld as per dwg t before welding mesh*	D3913 using DT9610A								
					k weld all mesh on basket as nd trim to clear fasteners hole								

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket***

4- Weld D4672-1 blanking plates as per dwg

DAS

*11**0***

Memo

0.00

13.10.23

9-89

Quality Control

											DQA:	Date:	5.
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	/ANCE / UP	DATE			
											QA Closed:	Date	
Work Orde	oŕ.			·		DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIK OIG	-					Rework	٦		Skid-tube	Crosstube	1	Water Jet	Engineering
Part I	No.					Scrap	1	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
				·		Use-as-is	1		noforming	Finishing	-	re/Packaging	Other
NCR I	No.					Work Order Update	1		Large Fab	Composite		Supplier	
			,					<u> </u>					
Root					-	ption of work order update		Initial		tion	Sign &		
Cause	,	Date	Step	Qty	C	or Non-conformance	Cr	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator	Ш												
Material	Ш												
Setup	Ш												
Other	Ш												
Process	Ш		ł	ł					:				ž,
Supplier	Ш						ı				1	İ	
Training													
Unapproved											<u> </u>	<u></u>	
						· · · · · · · · · · · · · · · · · · ·	AUI	LT CATE	GORY		-		
Landi	ing (Gear				General		=	-	_	_	_	_
		Bending			L	Bend		Grain			Ovalized		Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
		Crushed/	'Crimped			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		
		Heat Tre	at			Countersink	Г	Mislabe	led		Positioned \	N rong	_
		Inspection	n Strip in	Tube		Cut Too Short		Misread	I		Power Loss,	/Surge	Other
		Ripples in	n Bend			Drill Holes	Г	Offset		_			

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 107238 Page 2 September-23-13 11:36:18 AM Item ID: D3913-041 Accept *N900040100* Setup Start **Revision ID:** Item Name: Long Basket Base Assemby, 350 **Start Date:** 10/02/13 Start Qty: 1.00 **Cust Item ID:** Req'd Qty: 1.00 Required Date: 10/07/13 **Customer:** Reference: Run Approvals: **Process Plan:** Date: **Tooling:** Date: Stop Date: _____ SPC (Y/N): Date: Sequence ID/ Reject Reject **Operation Tool ID** Tool # Plan Accept Set Up/ Insp. **Work Center ID Description** Code Qty Qty Number Stamp **Run Hours** 120 QC5- Inspect part completeness to step on W/O 0.00 DAS *120* 13-10-23 0.00 Memo Quality Control

0.00

0.00

1 2/9/13-10:03

125

125
HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

Memo

NCR:	Vac	1	No
NCK:	Yes	/	No

Date:

NCR: Ye	·												
										QA Closed:	Date:		
Nork Order					DISPOSITION		·		AGAINST DI	EPARTMENT,	PROCESS		
			·		Rework	7 I		Skid-tube	Crosstube	7	Water Jet	Engineering	
Part No	٥.				Scrap	11	ſ	Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
					Use-as-is] [Therm	noforming	Finishing	Rec/Stor	e/Packaging	Other	
NCR N	0				Work Order Update] [Large Fab	Composite]	Supplier		
Root				Descri	tion of work order update	In	itial	Ad	ction	Sign &	***		
Cause	Date	Step	Qty	(or Non-conformance	Chie	ef Eng	Desc	cription	Date	Verification	QC Inspector	
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Material													
etup	- 4	j											
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rocess	<u>. </u>												
upplier	_	 				1	·						
raining	_												
Inapproved	<u> </u>	<u> </u>							,				
					F	AULT	CATE	GORY		*			
Landin	g Gear				General					-		-	
L	Bending			<u> </u>	Bend	Щ	Grain		_	Ovalized		Pressure/Forced	
]_	Centre N	lot Conce	ntric to	o/s	BOM/Route		Hardwa	re	L	Over/Under	tolerance	Temperature/Cure	
	Cracks			<u> </u>	Broken/Damaged	Ш	Inspecti	on incomplete		Part Incorred	it	Weld	
	Crushed	/Crimped			Burrs		Instruct	ions Incomplete,	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs				Contamination		Mainte	nance		Part Moved			
	Heat Tre	eat			Countersink		Mislabe	led		Positioned V		-	
	Inspecti	on Strip in	Tube		Cut Too Short		Misread	1	Ĺ	Power Loss/	Surge	Other	
1	Ripples	in Bend			Drill Holes	\bigsqcup	Offset					1	
[Torque '	Waves in I	Extrusio	n [Drawing	\square	Out of 0	Calibration				· .	
	Turning	Sequence	!		Finish	Out of Sequence							
Wave/Twist in Tube					Folio	Outside Dimensions							

407000

September-23-1.	3 11:36:18 Al	Д 30 М		"1()/:	7.38 "							Page 3	
Revision ID:	D3913-041			Accept	*N900	040	100)*	Setup	Start Stop	*N:	S1*	
Item Name: Start Date: Required Date: Reference:	10/02/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:				СССР	^N:	57*	
Approvals:	Process Plan	1:				ate:			Run	Start Stop		R1* R2*	
Sequence ID/ Work Center II		Operation Description White Gloss(Ref:4.3.5.2) ner OSI005 4 3-Steel	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	
130 Powdercoat Powder Coating		Memo 1- Plug holo coat 1ST COAT START TIN OVEN TEN FINISH TIN ********** 2ND COAT	es and mask only interior in the state of t	0.00 r of hinge (3) prior to powder 400. necessary***********************************	· ****				\$	/8	3-10- ₆	3 3	DAS 34 9-89
140 *140* QC Quality Control		QC3- Inspect Part Finish Memo	h	0.00				l×	<u></u>	<u>U</u>	13	10/20	l

NCR:	Yes	1	No
INCR.	162	1	INU

Date:

NCR: Ye	es / No				WORK ORDER NON-O	CON	FORM	MANCE / UF	PDATE					
	·· · · · · · · · · · · · · · · · ·									QA Closed:	Da	te:		
Work Ordei	, .				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS			
					Rework]		Skid-tube	Crosstube] _	Water Jet		Engineering	
Part N	o				Scrap	1		Machining	Small Fab	-	d. Eng. Coor.	Н	Quality	
NCR N	o				Use-as-is Work Order Update]		noforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	-	Other	
Root			I	Descri	ption of work order update	In	itial	Ad	ction	Sign &		\top		_
Cause	Date	Step	Qty	(or Non-conformance	Chie	ef Eng	Desc	cription	Date	Verificatio	n	QC Inspector	
Doc/Data														
quip/Tooling						1							•	
Operator														
Material		İ										İ		
etup														
Other	_													
rocess	_													
Supplier		1	1 1											
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Jnapproved														_
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Landin	-				General					٦				
<u> </u>	Bending			<u> </u>	Bend	\mathbf{H}	Grain		<u></u>	Ovalized		Н	Pressure/Forced	
	Centre N	ot Conce	ntric to (o/s	BOM/Route	\vdash	Hardwa			Over/Under		-	Temperature/Cure	
Ļ	Cracks				Broken/Damaged	\vdash	-	on incomplete	<u> </u>	Part Incorre		\vdash	Weld	
Ļ	Crushed/	Crimped			Burrs	-		ions Incomplete	/Unclear	Part Lost/M	issing	Ш'	Wrong Stock Pulled	
	Cuffs				Contamination	-		enance .	L	Part Moved				
Į.	Heat Trea				Countersink	-	Mislabe			Positioned V	_	_		
Ĺ	Inspectio		Tube		Cut Too Short	-	Misread	d	L	Power Loss/	Surge	Щ	Other	
]	Ripples in			<u></u>	Drill Holes		Offset							
1	Torque V	Vaves in I	Extrusion	՝ L	Drawing	Щ	Out of 0	Calibration						
	Turning S	-		L	Finish	$\boldsymbol{\vdash}$		Sequence						
Wave/Twist in Tube					Folio		Outside	Dimensions						

Work Orde September-23-1				*107	7238*			,				Page 4	
tem ID: Revision ID:	D3913-041			Accept	*N900	040	100)*	Setup		*N:	S1*	
	Long Basket	Base Assemby, 350								Stop	*N:	S2*	
Start Date:	10/02/13	Start Qty: 1.00	*1*		Cust Item I	D:							
Required Date: Reference:	10/07/13	Req'd Qty: 1.00	*1*		Customer:								
Approvals:	Process Pl	an:	Date:	Tooling:	Da	nte:			Run	Start	*N	R1*	
	QC:		Date:	SPC (Y/N):	Da	ite:				Stop	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description Assemble as per dwg		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	
150 HandFinish Hand Finishing		Memo Pick Kit		0.00				I				DAS 33 9-89	13-10-23
¹⁶⁰ *1հՈ*		QC5- Inspect part comp	leteness to step on W/O	0.00	DAS 27 1-89			1					
QC Quality Control		Мето		0.00 B [C) 4]								
170 *4 7 0 *		Identify as per dwg & S	tock Location:) 0.00 D# Q	30-041	B 107	246		\		/ Q	l 13(11	2(2()
170		.,		0.00					- / K		£		

0.00

Memo

Packaging

Packaging

											DQA:	Date:	<u></u>
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	AANCE / UPD	ATE			•
											QA Closed:	Date:	
Work Ord	٥٢٠					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
VVOIK OIG	٠					Rework	ı		Skid-tube	Crosstube		Water Jet	Engineering
Part I	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is	1 1		noforming	Finishing	i	re/Packaging	Other
NCR I	No.					Work Order Update	1		Large Fab	Composite		Supplier	
											-		
Root						ption of work order update		Initial	Actio		Sign &		
Cause	,	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator	\vdash										<u> </u>		
Material	\vdash												
Setup							l						
Other	_												
Process			}				Ì						
Supplier	-		ł										
Training	-		1										
Unapproved		<u> </u>	l	<u> </u>	}		:A111	LT CATE	GORY			1	L
Land	ing (Gear				General	701	LI CAIL					
		Bending				Bend		Grain		Г	Ovalized		Pressure/Forced
	 	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	ion Incomplete		Part Incorre	ct	Weld
		Crushed/	'Crimped			Burrs		Instruct	ions Incomplete/U	nclear	Part Lost/M	issing	Wrong Stock Pulled
	\sqcap	Cuffs	-			Contamination	Г	Mainte	enance		Part Moved	_	_
		Heat Tre	at			Countersink		Mislabe	eled		Positioned V	Vrong	_
		Inspectio	n Strip in	Tube		Cut Too Short	Г	Misread	1		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Drill Holes Drawing

Finish

Folio

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Run Hours

0.00

0.00

Work Center ID

180

Quality Control

180

Description

QC21- Final Inspection - Work Order Release

Memo

UB-10-24

MUJ 13-10-25

Qty

Qty

Code

Page 5

Insp.

Number Stamp

			DQA:	Date:	1
ICR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

NCR: Yes / No W	/(C		ļ
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QA Closed: Date: **AGAINST DEPARTMENT/PROCESS DISPOSITION** Work Order: Water Jet Engineering Skid-tube Crosstube Rework Machining **Small Fab** Quality Prod. Eng. Coor. Part No. Scrap Thermoforming Finishing Rec/Store/Packaging Other Use-as-is Work Order Update Large Fab Composite Supplier NCR No. Description of work order update Action Sign & Initial Root Verification **Chief Eng** Date Step Qty or Non-conformance Description Date QC Inspector Cause Doc/Data Equip/Tooling Operator Material Setup Other **Process** Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Ovalized Pressure/Forced Bend Grain Bending BOM/Route Over/Under tolerance Temperature/Cure - ** Hardware Centre Not Concentric to O/S Weld Broken/Damaged Inspection Incomplete Part Incorrect Cracks Part Lost/Missing Wrong Stock Pulled Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Moved Cuffs Contamination Maintenance Positioned Wrong Countersink Mislabeled Heat Treat Misread Power Loss/Surge Other Inspection Strip in Tube **Cut Too Short Drill Holes** Offset Ripples in Bend **Torque Waves in Extrusion** Drawing **Out of Calibration Turning Sequence** Out of Sequence Finish

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print September-23-13 11:36:17 AM Work Order ID: 107238 Parent Item: D3913-041 Start Date: 10/02/13 Required Date: 10/07/13 Parent Item Name: Long Basket Base Assemby, 350 Start Oty: 1.00 Required Oty: 1.00 Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM Component Item ID/ Replacement Mfg/ Last Unit of Qty on Qty per Kit Total Bin **Primary** Route **Qty** Date Item Name Item ID Location Measure Hand Location Seq ID Purch Item Issued Issued Qty D3913-1 No 100 Each 9.0000 Manufactured C 13-10-22 Rib B100460-Location Loc Qty Loc Code WA 97979 WA005 8 100460 7 88637 D3913-3 No 100 Each 10.0000 Manufactured B100443->(i) Rib Location Loc Qty Loc Code WA004

100442

100443 69160 84651

100483

101023 99781

100482

100

Loc Qty

11

4

3

Each

12.0000

Loc Code

WA005

Location

WA004

WA006

No

Manufactured

D3913-7

Rib

Page 1

Status

										DQA:	Date:	1
NCR: Yes	/ No				WORK ORDER NON-C	10:	VFOR	/ANCE / UP	DATE	QA Closed:	Date:	
Work Order:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No.					Rework Scrap Use-as-is		Thern	Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR No.			· · · · · · · · · · · · · · · · · · ·	<u></u>	Work Order Update			Large Fab	Composite	J	Supplier	
Root				Descri	ption of work order update	ı	nitial	Act	tion	Sign &		
Cause	Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling .	-	[•								
Operator]						:				ĺ	
Material]											
Setup]	
Other												
Process												

		·	FAULT CATEGORY		
Land	ling Gear	General			_
	Bending	Bend	Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped	Burrs	Instructions Incomplete/Unclean	r Part Lost/Missing	Wrong Stock Pulled
, .	Cuffs	Contamination	Maintenance	Part Moved	
	Heat Treat	Countersink	Mislabeled	Positioned Wrong	
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge	Other
ļ	Ripples in Bend	Drill Holes	Offset		
	Torque Waves in Extrusion	Drawing	Out of Calibration		
	Turning Sequence	Finish	Out of Sequence		
	Wave/Twist in Tube	Folio	Outside Dimensions		

Supplier Training Unapproved

Picklist Print

September-23-13 11:36:17 AM

Page 2

Work Order ID: Parent Item: Parent Item Name:	107238 D3913-041 Long Basket Base Assemby, 350						Date: 10/02/13	Required Date: 10/07/13 Required Qty: 1.00
D3913-9 Hinge Rib	Manufactured	No		100	Each	4.0000	1	1 <i>CC 13-10-2</i> 2
-			Location	Loc Qty		Loc Code	+	3100305-1
			WA004	3			-	7100 303 7 (1)
			102353	3				
•			WA005	1				
			70138	1				
D3916-5 Light Rib	Manufactured	No		100	Each	18.0000	3	3 <i>CC 13-10-</i> 22
			Location	Loc Qty		Loc Code		3103752-3
			WA004	3				
			104316	1		,		· · · · · · · · · · · · · · · · · · ·
			94698	2		•		``
			WA005	15				· ·
			103589	6				
			103590	4				
			77142	1				
ed i			82933	4				B-17
D3916-041 Rib Assembly	Manufactured	No		100	Each	10.0000	2	² (L 13-10-22
			Location	Loc Oty		Loc Code	3	102 868 - (2)
			WA004	8				
			100359	8				
			WA005	2				
			81444	2				·

		DQA:	Date:	•
NCR· Ves / No	WORK ORDER NON-CONFORMANCE / UPDATE			

QA Closed: Date: **DISPOSITION AGAINST DEPARTMENT/PROCESS** Work Order: Engineering Skid-tube Crosstube Water Jet Rework Prod. Eng. Coor. Quality Machining Small Fab Part No. Scrap Thermoforming Finishing Rec/Store/Packaging Other Use-as-is Work Order Update Large Fab Composite Supplier NCR No. Sign & Description of work order update Root Initial Action Verification **QC** Inspector Chief Eng Description Step or Non-conformance Date Date Qty Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Pressure/Forced Ovalized Bend Grain Bending BOM/Route Over/Under tolerance Temperature/Cure Hardware Centre Not Concentric to O/S Broken/Damaged Weld Inspection Incomplete Part Incorrect Cracks Wrong Stock Pulled Crushed/Crimped Instructions Incomplete/Unclear Part Lost/Missing Burrs Contamination Maintenance Part Moved Cuffs Heat Treat Countersink Mislabeled Positioned Wrong Other Inspection Strip in Tube **Cut Too Short** Misread Power Loss/Surge Drill Holes Offset Ripples in Bend Torque Waves in Extrusion Drawing Out of Calibration

Turning Sequence

Wave/Twist in Tube

Finish

Folio

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

September-23-13 11:36:17 AM

Work Order ID:	107238							
Parent Item:	D3913-041					Star	t Date: 10/02/13	Required Date: 10/07/13
Parent Item Name:	Long Basket Base Assemby, 350					Sta	rt Qty: 1.00	Required Qty: 1.00
D4017-7 Rib	Manufactured	No		100	Each	9.0000	3	3 (C 13-10-22 6799——(3)
			Location	Loc Oty		Loc Code	B10	6799-3
			WA004	5				_
•			94821	5				_
			WA005	4				
			69730	1				-
			82969	1				
			85435	1				<u></u>
			88392	1				_
D4017-9 Rib	Manufactured	No		100	Each	17.0000	2	2 ((13-10-27
			Location	Loc Qty		Loc Code		B106922->
			WA004	10				_
			107114	10				_
			WA005	7				_
			100536	4				_
			70341	2				·
			81445	1				· <u>·</u>
D4034-041 Aft Upper Rib Assembly	Manufactured	No		100	Each	7.0000	1	1 ((13-10-27
			Location	Loc Qty		Loc Code		B104951-27
			WA004	6				_
			103357	2				
			104214	4				_
			WA005	1				
			84048	1				_

							DQA:	Date:	1
NCR: Ye	s / No			WORK ORDER NON-C	ONFORM	MANCE / UPDATE	QA Closed:	Date:	
Work Order	•			DISPOSITION		AGAINST	DEPARTMENT	/PROCESS	
Part No).			Rework Scrap Use-as-is	l B	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite	Pro Rec/Stor	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR No). 			Work Order Update		Large Fab Composite		Supplier	
Root				Description of work order update	Initial	Action	Sign &		
Cause	Date	Step	Qty	or Non-conformance	Chief Eng	Description	Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling				. •					
Operator		ļ							
Material		Ī.							
Setup							,		
Other						·	İ		
Process									
Supplier			1	·					
Training		ľ							

Ovalized Pressure/Forced Bending Bend Grain Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperature/Cure Broken/Damaged Inspection Incomplete Part Incorrect Weld Cracks Wrong Stock Pulled Crushed/Crimped Instructions Incomplete/Unclear Part Lost/Missing Burrs Part Moved Cuffs Contamination Maintenance Positioned Wrong Heat Treat Countersink Mislabeled Cut Too Short Misread Power Loss/Surge Other Inspection Strip in Tube Drill Holes Offset Ripples in Bend Torque Waves in Extrusion Drawing Out of Calibration Finish Out of Sequence Turning Sequence Wave/Twist in Tube Folio Outside Dimensions

FAULT CATEGORY

General

Unapproved

Landing Gear

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

September-23-13 11:36:17 AM

Work Order ID:	107238 D3913-041								D 4 10/02/12		10/07/12
Parent Item: Parent Item Name:	Long Basket Base A	scamby 250							Date: 10/02/13 Qty: 1.00		Required Date: 10/07/13 Required Qty: 1.00
	Luig basket base A	-									- · · ·
D4034-043 Fwd Upper Rib Assemb	ıly	Manufactured	No			100	Each	9.0000	1	1	CC 13-10-22 B107159-
				Location	<u>!</u>	Loc Oty		Loc Code		ন	B107159-71
•				WA		1					
					103421	1					
				WA004		5					. 1•
					104209	5			•		
	•			WA005		3					
					103355	1					
•					82980	2					
D2581		Manufactured	No			100	Each	103.0000	2		
Mounting Bracket		ivianulactureu				.00	Zue	105.000	<u>-</u>		(13-10-22
*				I	_	1 05.	•	1 C-4-			13-10-22 B103076->
				Location		Loc Qty		Loc Code		•	\$ 103076 - >
				WA004		103					
					103076	24					
					103952	17					
					105886	48					
					70766	2					•
					81253 82506	2					
	*				83230	3					·
					85452	2					
					87706	2				-	S.
					99837	2					
D2931		Manufactured	No		,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	150	Each	2,122.0000	2		DAS
Bumper		wianaractarea							and the same that are the same of the same	-	33 <i> 3-10-</i> 2
•				Locatio	n	Loc Qty		Loc Code			9-89
				GA	-	124					
				UA	46064	124			460	64	
	•			0.000	40004				700		
				ST021	06425	1998					
					86435	1998					*

											DQA	۸: D	ate:	· ·
NCR:	Yes	/ No				WORK ORDER NON-	100	NFORM	MANCE / UP	DATE	QA Closed	d: D	ate:	
Work Orde	er.			•		DISPOSITION				AGAINST DI	EPARTMEN	T/PROCESS		
Part N	No.	•				Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Je od. Eng. Coor ore/Packagin Supplie	r g	Engineering Quality Other
Root					Descri	ption of work order update	T	Initial	Act	tion	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ct	nief Eng	Desci	ription	Date	Verificati	on	QC Inspector
Doc/Data		*												
Equip/Tooling														
Operator			ļ											
Material]												
Setup			ļ											
Other														
Process			1									Ì		
Supplier				-										
Training]	1									ļ		
Unapproved							L							
				_		F	:AUI	LT CATE	GORY				:	
Landi	ing (Gear				General	_	_			_		_	1
	L	Bending			L	Bend	L	Grain			Ovalized		\perp	Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route	L	Hardwa	are	<u> </u>	Over/Und	er tolerance		Temperature/Cure
		Cracks				Broken/Damaged	L	Inspect	ion Incomplete		Part Incor	rect	L	Weld
		Crushed	Crimned			Rurrs		Instruct	tions incomplete/	Unclear	Part Lost/	Missing	1	Wrong Stock Pulled

Maintenance

Out of Calibration
Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short Drill Holes

Drawing

Finish

Folio

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

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September-23-13 11:36:17 AM

Work Order ID:	107238										
Parent Item:	D3913-041						Start	Date: 10/02/13]	Required Date: 10/07/13	
Parent Item Name:	Long Basket Base Ass	semby, 350					Start	Qty: 1.00		Required Qty: 1.00	
D3913-15 Wide Handle Plate		Manufactured .	No		100	Each	9.0000	1	1	((13-10)	<u> </u>
				Location	Loc Qty		Loc Code	•	77	1719 -> (\bigcirc
				WA004	9						$\overline{}$
				104675	4						
				97719	5						
D4016-1 Hinge Half, Base		Manufactured	No		100	Each	68.0000	3	3	CC 13-10-2	?Z
				<u>Location</u>	Loc Qty		Loc Code	310	341	4-3)
				WA004	68						
				103414	28			· 		•	
				104200	20						
				106646	20						•
D4021-I Handle Plate		Manufactured	No		100	Each	55.0000	3	3	(C 13-10-	22
				Location	Loc Oty		Loc Code	B	105	883	.3
				WA004	55			,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,		`	
				100366	8						
				100649	4						
				103509	25						
				105883	15						
				94596	3					DAS	
D4021-5 Blanking Plate		Manufactured	No		100	Each	34.0000	2	2	33 9-89 / 3-	-16-23
				Location	Loc Qty		Loc Code				
				ST084	34						
				103399	27			1033	399		
				103829	6			,	—		
				85065	1						

											DQA:	Date:	5
NCR:	/es	/ No				WORK ORDER NON-C	100	NFORM	AANCE / UPD	DATE			
											QA Closed:	Date:	
Work Orde	ar.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIK OIG	-					Rework	1		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	J۵					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•••					Use-as-is	1		noforming	Finishing	1	re/Packaging	Other
, NCR I	No.					Work Order Update	i I		Large Fab	Composite	1100,010	Supplier	1
	-					' <u>L</u>	'		·	· L		٠٠٠ ــــــــــــــــــــــــــــــــــ	·
Root			** *		Descri	ption of work order update	1	Initial	Acti	on	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector
Doc/Data	Ш												
Equip/Tooling	Ш	-											
Operator		•	İ										
Material													
Setup	Ш												
Other											1		
Process													
Supplier													•
Training	Ш			, r.*								:	
Unapproved													
						F	AUL	T CATE	GORY				
Landi	ng G	iear			_	General	_	,			.	_	7
		Bending				Bend	L	Grain		L	Ovalized	<u></u>	Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/U	Inclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		
		Heat Trea	it			Countersink		Mislabe	led		Positioned V	Vrong	_
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence
Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

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Work Order ID: Parent Item: Parent Item Name:	107238 D3913-041 Long Basket Base A	Assemby, 350						Date: 10/02/13 Qty: 1.00	Required Date: 10/07/13 Required Qty: 1.00
D4020-11 End Mesh, Basket		Manufactured	No		100	Each	25.0000	2	² (C /3-10-27
				Location	Loc Qty		Loc Code		•
				WA004 107053	22 22 3			2	
				81442	2				- ,
				84972	1				<u>.</u>
D4672-1 Blanking Plate		Manufactured	No		100	Each	12.0000	2	2 [[13-10-77
				Location	Loc Qty		Loc Code	了100	0830 ~ (2)
				WA004	8				
				101186	2				
				105887	6				-
				WA005	4				· · ·
				88253	4				-
M304EX0.75-16F Expanded Metal Flat SS		Purchased	No		100	sf	864.2736		33 CC 13-10-22
				Location	Loc Qty		Loc Code	n	1136895-
				WA007	864.2735977				
				125457	0.00004402				_
				M126052	42.02608				_
				M126134	108.417474			-	_
				M126500	73.83				-
				M126899	640				_

											DQA:	Date:	
NCR: Y	es ,	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UPDATI		QA Closed:	Date	
Work Orde	ri.	-				DISPOSITION			A	GAINST DE			
Part N						Rework Scrap			⊢	osstube nall Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	 No					Use-as-is Work Order Update			~	inishing nposite	Rec/Stor	re/Packaging Supplier	Other
Root					Descri	ption of work order update	1	nitial	Action		Sign &		
Cause		Date	Step	Qty	,	or Non-conformance	Ch	ief Eng	Description	n	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling							ļ		:				
Operator													
Material				:	,							,	
Setup				i									
Other							l						
Process													
Supplier							1					Ì	
Training													
Unapproved							<u> </u>			··········			
						F	AUL	T CATE	GORY				
Landi	ng G	ear				General	_	-					7
	L	Bending				Bend		Grain			Ovalized	_	Pressure/Forced
	Щ°	Centre No	ot Concei	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Ц̈́	Cracks				Broken/Damaged	L	Inspect	ion Incomplete		Part Incorre	⊢	Weld
	Ц̈́	Crushed/	Crimped			Burrs		instruct	ions Incomplete/Unclea	ar 🗀	Part Lost/Mi	issing	Wrong Stock Pulled
	∐'	Cuffs				Contamination		Mainte	enance		Part Moved		
		Heat Trea	at			Countersink		Mislabe	eled		Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

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Picklist Print

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Work Order ID: Parent Item:	107238 D3913-041					Stort I	Date: 10/02/13		Required Date:	10/07/12
Parent Item Name:	Long Basket Base Assemby, 350						Qty: 1.00		Required Qty:	
MS20600-AD4W3	Purchased	No		150	Each	729.0000	2	2	DAS 33	
Cherry Rivets							C		9-89	3
			Location	Loc Oty		Loc Code				
			ST311	596						
			122151	4			**			
			122452	4						
			123525	288						
			124231	300						
			WA003	133			124	231		
			107939	133						,
MS21042L3	Purchased	No		150	Each	5,946.0000	6	6	DAS 33	13-10-2
Nut							-		9-89	1310-0
			Location	Loc Qty		Loc Code				y
			FP001	3						
			122141	3						٠,
			GA	18						
			122452	18						
			ST314	304						
			111668	1			-			
			117885	32						
			119017	55						
			119075	138						
			123265	43			-	 -		
			M126036	35			-			
			ST506	1249						
			123900	870						
			124291	379						
			ST510a	4372						
			M126275							
			M126273 M126333	372 4000			126	333		
			IVI 1 20333	4000			100			

											DQA:	Date	e:				
NCR:	⁄es	/ No				WORK ORDER NON-	COI	NFORM	QA Closed:	Date							
		·									QA Closed:	Date	:				
Work Order:						DISPOSITION	AGAINST DEPARTMENT/PROCESS										
Work Orde	-					Rework		Skid-tube	Crosstube	7	Water Jet	Engineering					
Part No.						Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality					
	•••		· .	.,		Use-as-is		noforming	Finishing	-1	re/Packaging	Other					
NCR I	Vo.					Work Order Update			Large Fab	Composite		Supplier					
	•																
Root			ĺ			ption of work order update		Initial	Act	ion	Sign &						
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	QC Inspector				
Doc/Data	Ш																
Equip/Tooling	Ш																
Operator	Ш								i								
Material	Ш																
Setup							1										
Other				}								1					
Process												ì					
Supplier																	
Training			Į	1 1													
Unapproved												<u> </u>					
							AUI	LT CATE	GORY								
Landi	_	7			_	General	7		_	7	Г	-					
	<u> </u>	Bending			<u> </u>	Bend	_	Grain		<u></u>	Ovalized	-	Pressure/Forced				
	L	Centre N	ot Conce	ntric to O)/S	BOM/Route	<u> </u>	Hardware			Over/Under	-	Temperature/Cure				
		Cracks			<u> </u>	Broken/Damaged	—	-1	on Incomplete	<u> </u>	Part Incorre	⊢	Weld				
	\vdash	Crushed	/Crimped		<u> </u>	Burrs	\perp	-	ions Incomplete/l	Jnclear	Part Lost/M	issing	Wrong Stock Pulled				
	\vdash	Cuffs			Ŀ	Contamination	\perp	Mainte			Part Moved						
		Heat Tre			L	Countersink		Mislabe			Positioned \						
		1 '	on Strip in	Tube		Cut Too Short		Misread	d		Power Loss	'Surge	Other				
	1	Ripples i	n Bend			Drill Holes	1	Offset									

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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Picklist Print

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Work Order ID: Parent Item: Parent Item Name:	107238 D3913-041 Long Basket Base A	Assemby, 350	· · · · -				Pate: 10/02/13 Qty: 1.00	,	Required Date: 10/07/13 Required Qty: 1.00			
NAS1149F0332P Washer		Purchased	No			150	Each	8,538.0000	12	12	33 9-89	No.
				Location	<u>n</u>	Loc Qty		Loc Code				
				GA		182						
					122063	182						
				ST294		158						
					122063	158						
				ST295		3						
					123352	3				-		
				st510		3195						
					123900	3195						
				ST510a		5000			123	900		
					125646	5000					D40	
AN3-10A Bolt		Purchased	No			150	Each	350.0000	6	6	DAS 33 9-89	ci.
				Locatio	<u>n</u>	Loc Qty		Loc Code			0 00	
				ST351		14						
					124221	3						
					124858	11						
				ST513		336				-		
					m125709	336			123	709		
AN960JD8 Washer	NAS1149DN832J	Purchased	No			150	Each	0.0000	2 	2 963/°	DAS 7 33 9-89	13-10-2

												DQA.	υa	ite.			
NCR: Y	Yes	/ No				WORK ORDER NON-O	(QA Closed:	 Da	ite:							
Work Orde	or.					DISPOSITION		AGAINST DEPARTMENT/PROCESS									
Part N	- ۱۰۰					Rework Scrap Use-as-is Work Order Update		Skid-tube Machining Thermoforming Large Fab		Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other		
Root					Descri	ption of work order update		Initial	Ac	tion	Т	Sign &					
Cause	l	Date	Step	Qty		or Non-conformance	Cr	nief Eng	Desc	ription	1	Date	Verificatio	n l	QC Inspector		
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved																	
						F	AUI	LT CATE	GORY								
Landi	ng (Gear				General		_									
Bending Centre Not Concentric to O/S Cracks						Bend BOM/Route Broken/Damaged		Grain Hardware Inspection Incomplete			٦̈́	Ovalized Over/Under tolerance Part Incorrect			Pressure/Forced Temperature/Cure Weld		

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

DOA.

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Wrong Stock Pulled

Other

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

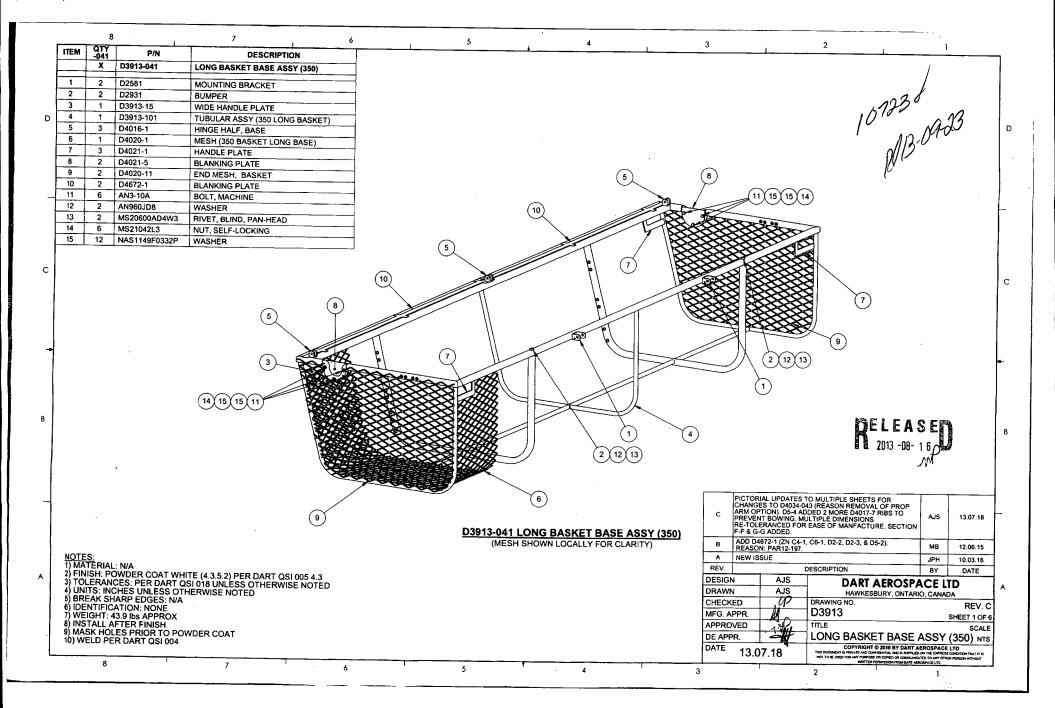
Cut Too Short

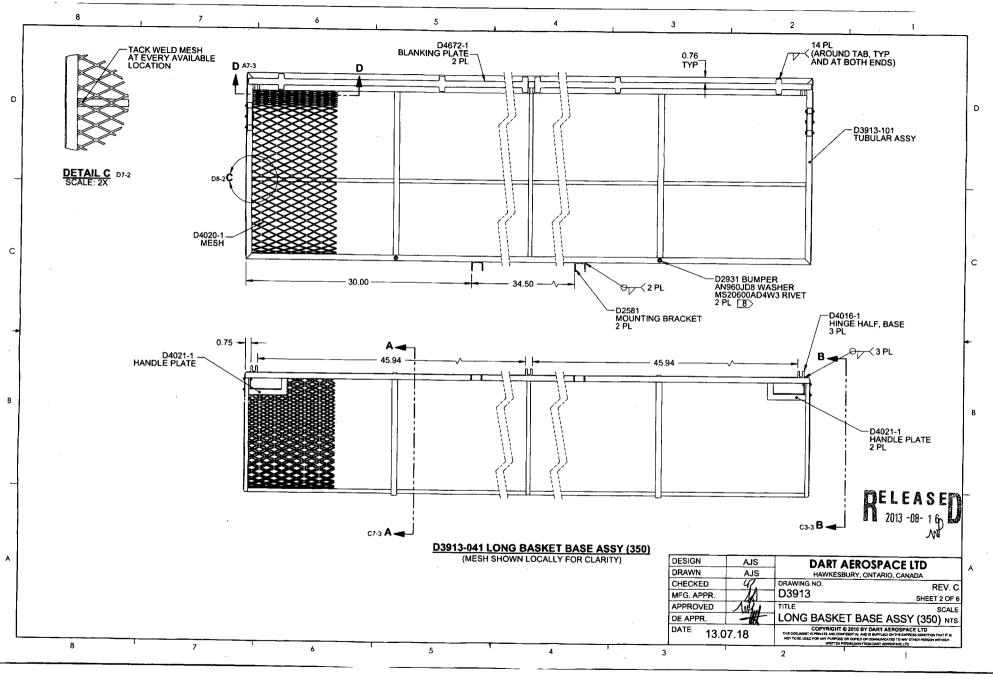
Drill Holes

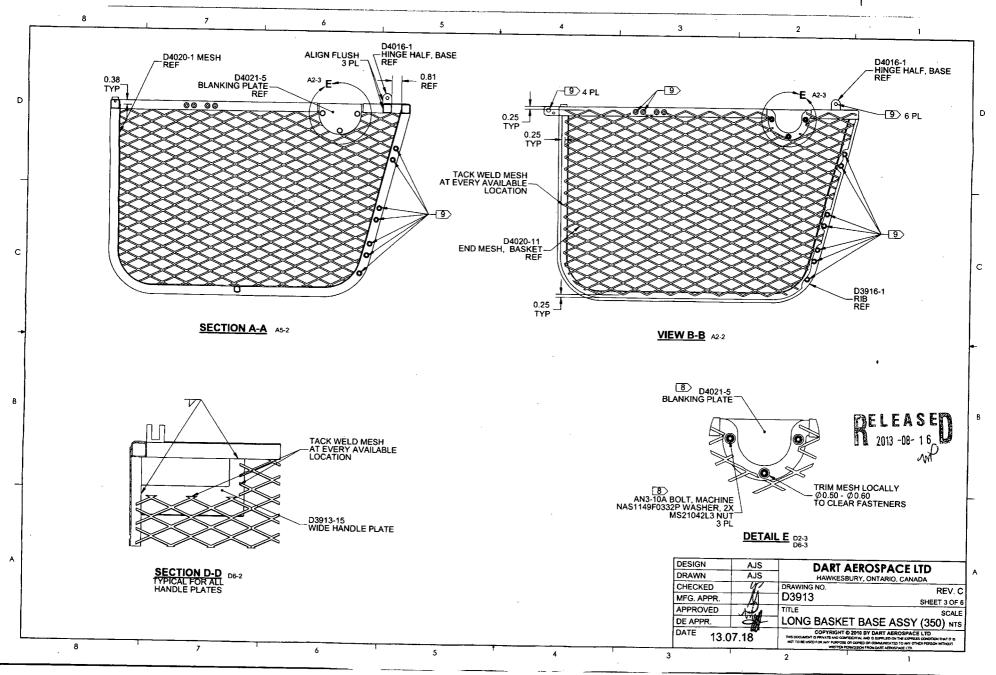
Drawing

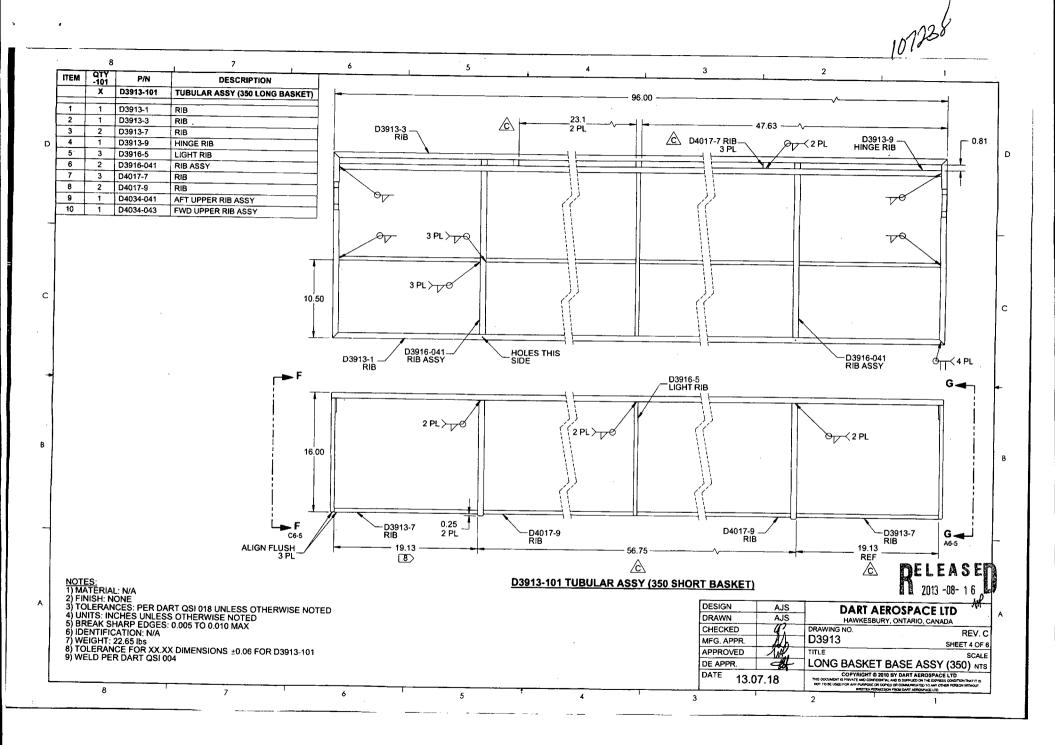
Finish

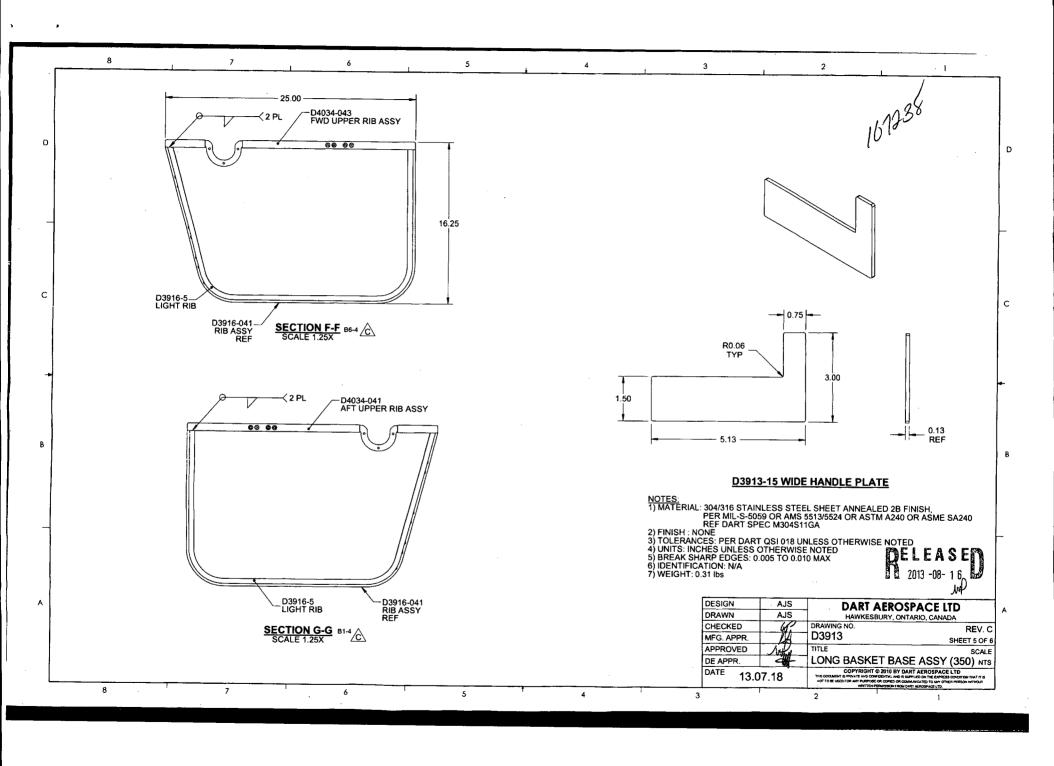
Folio

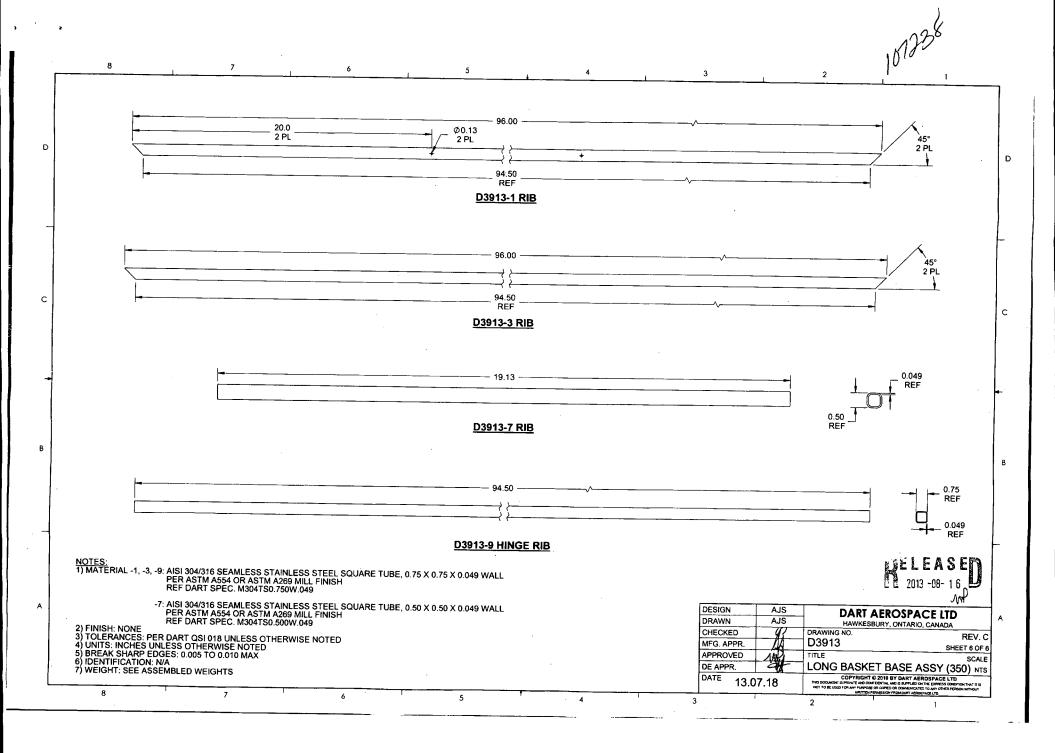












8 2 23.6 -D 15.61 15.13 19.52 -(SEE D4020-1 F FOR LENGTH) TYP D4020-3 (350 BASKET SHORT, BASE) (SEE D4020-3F FOR LENGTH) NOTES: 1) MATERIAL-1: MAKE FROM D4020-1F -3: MAKE FROM D4020-3F 2) FINISH: NONE A NEW ISSUE 10.03.04 REV. DESCRIPTION BY DATE DESIGN AJS 2) FINISH. NONCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHAPP EDGES: N/A
6) IDENTIFICATION: N/A DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4020 MFG. APPR. 6) IDENTIFICATION. 1974.
7) WEIGHT: SEE D4020-1F & D4020-3F
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY SHEET 1 OF 4 APPROVED TITLE SCALE 350 BASKET MESH (BASE) DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS FROM TO ADD COMPETENT AND IS IMPRESS OF THE EDRESS CONDITION THAT IT
NOT TO BE USED FOR MAY PAPPOSE OF COMPETEN COMPACTION TO MAY OTHER PERSON WITHOUT
WRITTEN PERSONSION FROM DART ADDISPASS. DATE 10.03.04 8

D4020-5: 95.25 D4020-7: 56.00 D С 21.75 2.00 1.25 D4020-7 D4020-5 25.00 44.66 D4020-5 MESH (350 BASKET LONG, LID) (LOCAL SECTION MESH SHOWN FOR CLARITY) D4020-7 MESH (350 BASKET SHORT, LID) (LOCAL SECTION MESH SHOWN FOR CLARITY) NOTES: 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F REF DART SPEC. M304EX0.75-16F REF DART SPEC. M304EX0.75-16F

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: N/A

7) WEIGHT -5: 0.80 ibs APPROX DESIGN AJS DART AEROSPACE LTD DRAWN JPH HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D4020 MFG. APPR. SHEET 2 OF 4 7) WEIGHT -3: 0.00 IDS AFFICIAN
-7: 4.49 IBS APPROX
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06. APPROVED TITLE SCALE 350 BASKET MESH (BASE) NT:

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THE DODARANT DIRWINT NA COMMENTAL BUT SUPPLIED WHILE THE SECRETION HAS THE SECRETION HAS THE SECRETION HAS THE SECRETION HAS THE SECRETION HAS THE SECRETION HAS THE SECRETION HE SECRET DE APPR. NTS DATE 10.03.04 8 5

0.40 8 R1.44 REF 15.50 2.00 0.38 5.64 R3.38 3 2 PL 20.18 9 D4020-11 END MESH, BASKET

DESIGN AJS DART AEROSPACE LTD DRAWN JPH HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A MFG. APPR. D4020 SHEET 3 OF 4 APPROVED TITLE SCALE 350 BASKET MESH (BASE) DE APPR. NTS COPYRIGHT © 2019 BY DART AEROSPACE LTD
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NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F

REF DART SPEC. M304EXU.75-10F

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: N/A

8

6) IDENTIFICATION: N/A
7) WEIGHT: 122 Ibs
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) TOLERANCE ON XX.XX DIMENSIONS \pm 0.06.

6

8

3

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